


Date: Friday, 10/5/2007 7:53:44 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WELDMENT TOP PANEL	PROTOTYPE
Job Number : 35015	Part Number : D36509	
Estimate Number : 13034	Drawing Number : D3650 UNDER REVIEW	FOR ENGINEERING USE ONLY
P.O. Number :	Project Number : N/A	
This Issue : 10/5/2007 S.O. No. :	Drawing Revision : U/R	
Prsht Rev. : NC	Material :	
First Issue : / / Type : SMALL /MED FAB	Due Date : 10/12/2007	Qty: 2 Um: Each
Previous Run :		
Written By : 		
Checked & Approved By :		
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S24GA	304/316 .025 Sheet
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Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.1071 sf(s)
 304/316 SS sheet 24 ga (0.025" thick)
 Batch: 105529 13 07-10-9

CERTIFICATE OF CONFORMITY
 REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3650

Dwg Rev: PRE 13 07-10-9
 Prog Rev: PRE

2-Deburr if necessary 13 07-10-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3650

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 35015

Part Number: D36509

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

11/05/10

JB 07.11.22

①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



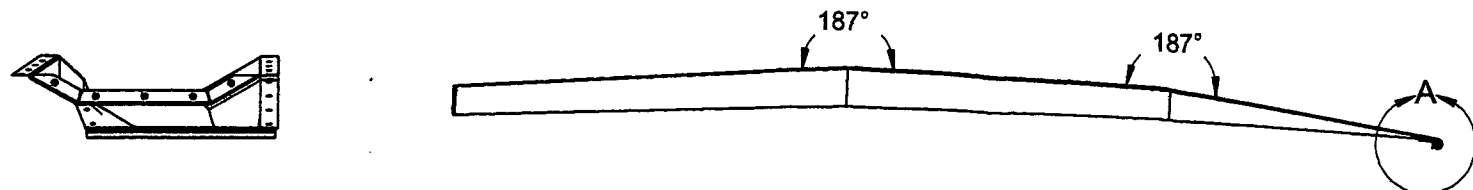
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11.07.11.22

QC5 ↑

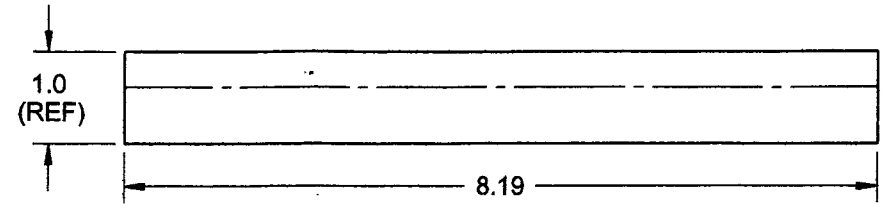


MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

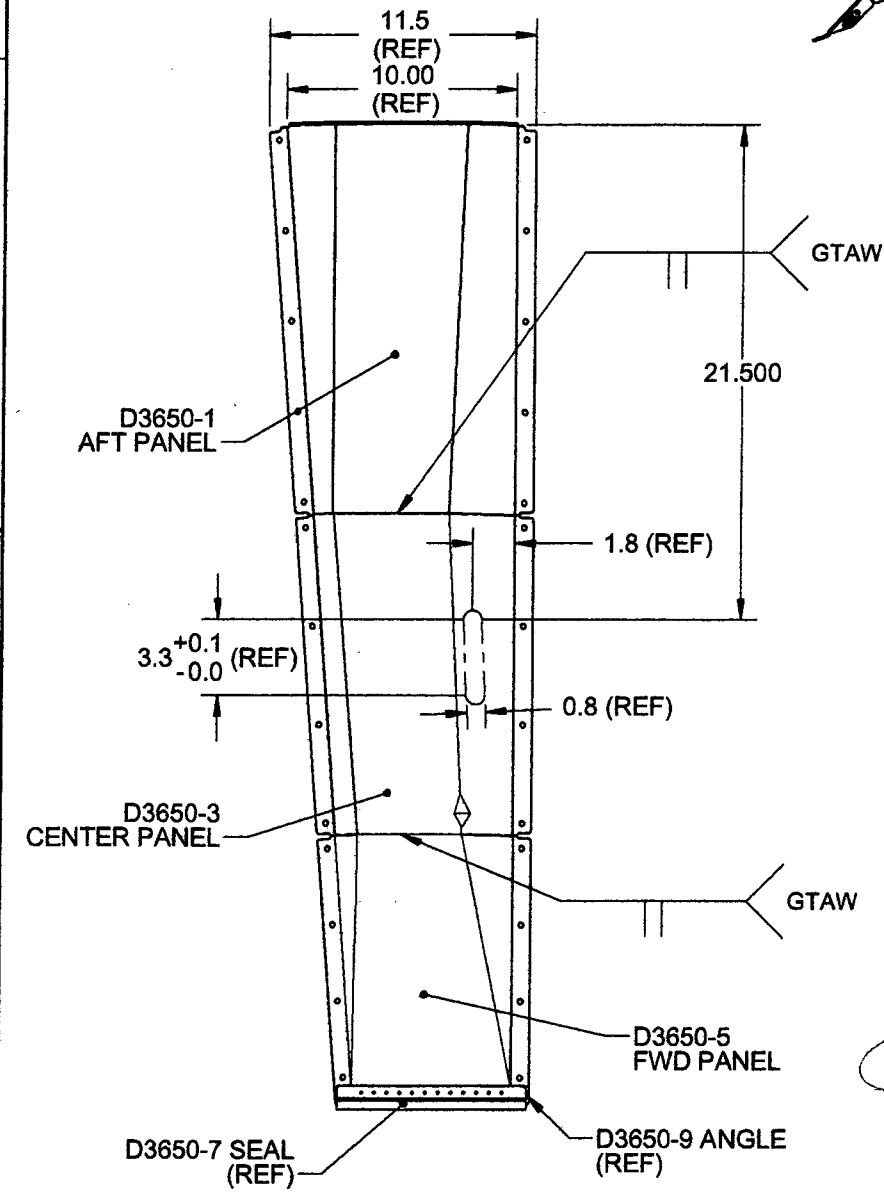
MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(3 PLACES)



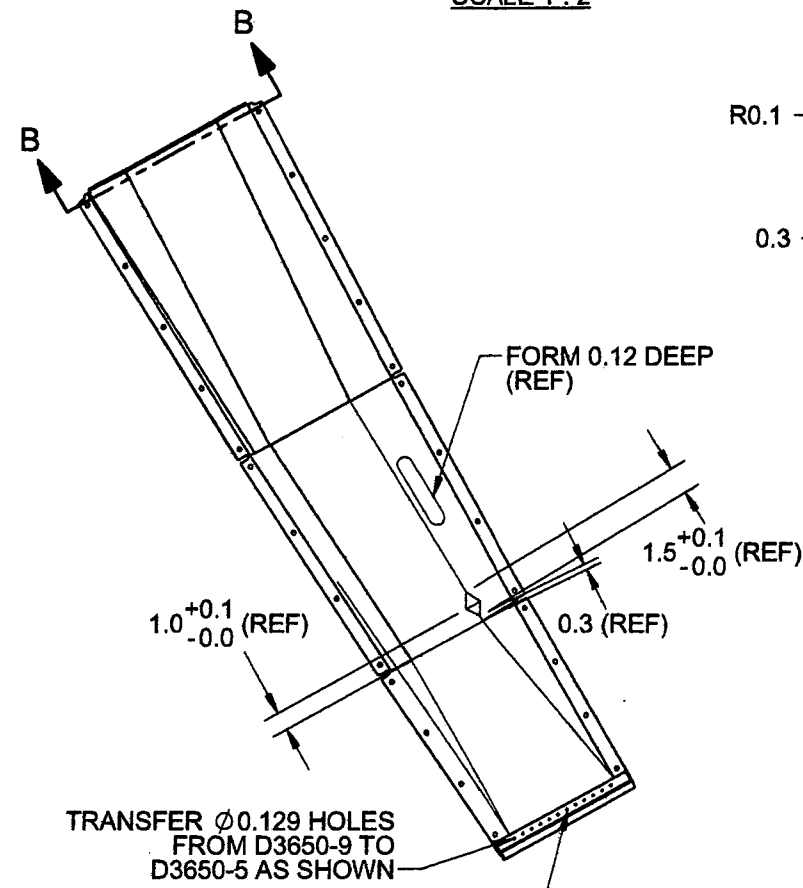
D3650-7:
1) MATERIAL: P/N 41521X120HK-FT TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: KIRKILL-TA
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES



D3650-7 SEAL
(SCALE 1:2)

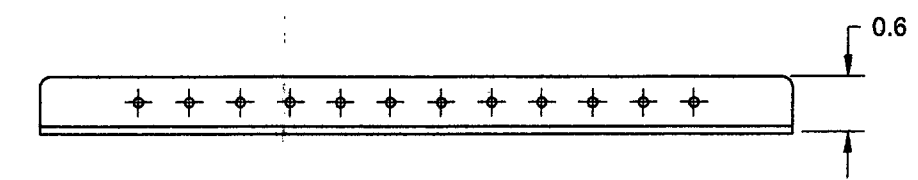
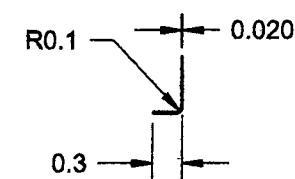


D3650-041 WELDMENT TOP PANEL ASSY
(WELD PER DART QSI 004)

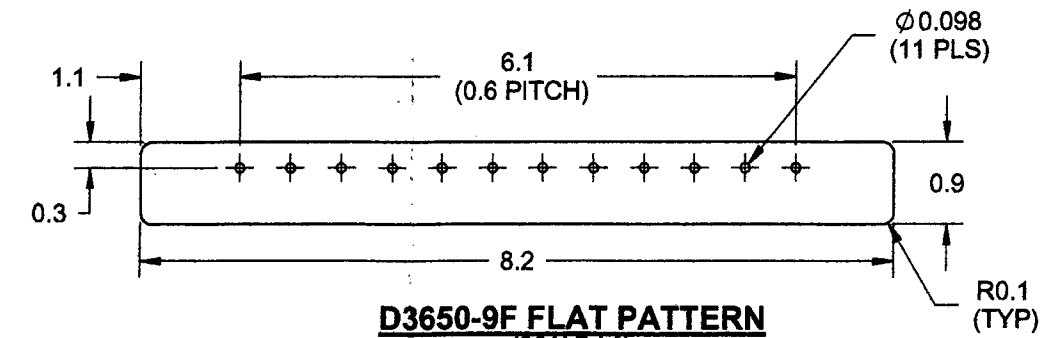


TRANSFER Ø0.129 HOLES
FROM D3650-9 TO
D3650-5 AS SHOWN

INSTALL
X CR3523-4-03 (NAS9307M-4-03) RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)
(SCALE 1:2)



D3650-9F FLAT PATTERN
(SCALE 1:2)

D3650-9 NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.025 (24 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC.M304S24GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

A	07.09.10	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED	DRAWING NO. D3650 REV. A SHEET 1 OF 4
DATE 07.09.10	TITLE WELDMENT TOP PANEL	SCALE 1:8
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Hawksbury, Ontario K6A 1K7

Phone: (613) 632-3336

Fax: (613) 632-4443

Purchase From:

Campi Steel
935 Boul. Du Havre
Valleyfield, QC J6S 5L1

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00004550

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304S24GA	304/316 .025 Sheet PER MIL-S-5019 (ANNEALED) 2 B FINISH MATERIAL: AISI 304/316 SS SHEET B/N105592	96.0000	sf	5.600000	537.60	Sep 13, 2007

Comments:

10004 BU104

Certificate of Mill Test Results
BL TO 403681-002 23Mar07
Pg 1/1

YIEH MAU CORP.

MILL TEST CERTIFICATE

INVOICE NO. : F08M648
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304, ASTM A242/A430
CUSTOMER :

inox
24 JA 48 X 96

ORIGINAL

668, KUNIN AN RD. LI CHU HSIAO
KACHUNG TAIWAN R.O.C.
TEL: 07-878886 FAX: 07-878800
CERTIFICATE NO. F08M648
DATE OF ISSUE: 07/03/2008
PAGE: 4

24 JA 48 X 96

CERTIFICATE NO: 7640446
DATE OF ISSUE: 07/01/2008
PAGE: 4

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL-50 mm					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	SI x100	Mn x100	P x1000	S x1000	NI x100	Cr x100	N x100
AISI 304/316 (WITH PAPER INTERLEAVED)																		
24GA / 48" X 96"	1	1,403	3,091	TK404411	55872295B-1	367	650	58	80	158	4	84	181	27	1	807	1818	4.9
24GA / 48" X 96"	1	1,403	3,091	TK404411	55872295B-2	367	650	58	80	158	4	84	181	27	1	807	1818	4.9
24GA / 48" X 96"	1	1,404	3,095	TK404411	55872295B-3	367	650	58	80	158	4	84	181	27	1	807	1818	4.9
24GA / 48" X 96"	1	1,518	3,347	TK404399	55872295B-22	368	671	57	80	158	4.2	83	187	26	1	803	1810	5
24GA / 48" X 96"	2	1,517	3,345	TK404399	55872295B-23	368	671	57	80	158	4.2	83	187	26	1	803	1810	5
24GA / 48" X 96"	1	1,679	3,704	TK404399	55872295B-34	368	671	57	80	158	4.2	83	187	26	1	803	1810	5
TOTAL:	6	8,710	19,228															

Remarks: NO MERCURY CONTAMINATION

Use mercury carefully that the material is not contaminated

Good test good for all Heat No.

Remedy: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Good test good for all Heat NO.

YIEH MAU CORP.

Lia Kun Huang
Manager of Quality Assurance Division